

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026984**Date Inspected:** 03-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Rick Bettencourt randomly observed ABF/JV qualified welder Jason Collins #8128 performing Flux Cored Arc Welding (FCAW) with .072" diameter NR232 electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-2160-1-4G. The QA Inspector noted the ABF welder had previously fit and tacked the channel steel and plate to the modified bike path box panel at the bike path expansion joint side. This work was located at West line expansion joint "C". During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters. Welding parameters were recorded as 240 Amps, 22 Volts and a travel speed of 375mm/min. The QA Inspector noted the above parameters did appear to comply with the contract requirements.

The QA Inspector noted the welding was nearly completed at the above identified location upon the arrival of the QA Inspector in the AM. The QA Inspector noted the welding was completed by lunch time on this date. The QA Inspector randomly observed the QC Inspector perform visual testing of the completed welds for the modification of the above identified expansion joint. The QA Inspector noted the QC Inspector indicated the welds were acceptable after completion of the inspection. The QA Inspector performed a random visual and dimensional inspection of the completed fabrication and noted the welding was completed with satisfactory results.

The QA Inspector noted the painting contractor has moved in to begin coating the recently welded and installed material. The QA inspector observed the welding contractor begin moving the equipment down to the expansion joint B to begin demolition and fabrication of the PS-19 MODS.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No pertinent conversation noted on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
